

Date: Thursday, 10/18/2007 8:03:34 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 35213		
Estimate Number	: 11403		
P.O. Number	: N/A	Part Number	: D3296041
This Issue	: 10/18/2007 S.O. No. : N/A	Drawing Number	: D3296 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 33124	Material	: N/A
Written By	: <u>7/10/10.18</u>	Due Date	: 10/31/2007
Checked & Approved By	: <u>7/10/10.18</u>	Qty:	8 Um: Each
Comment	: Est. C 05.10.14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32961	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	B 35232

FF 07-11-05 (8)

2.0	D32963	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door Panel		B 35233 x 7 B 33126 x 1

FF 07-11-05 (8)

3.0	D31617	Hinge 14"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Hinge 14"

Batch: B 33190 x 5 / B 35506 x 3 \*

FF 07-11-05 (8)

4.0	D31619	Hinge 17"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Hinge 17"

Batch: B 35229

FF 07-11-05 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 10/18/2007 8:03:34 AM

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Drawing Name: DOOR ASSEMBLY

Job Number: 35213

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total : 200.0000 Each(s)

Rivet, Universal Head

Batch: M 105125

FF 07-11-05 (8)

6.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Fabricate &amp; assemble as per Dwg D3296.

FF 07-11-06 (8)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 2/11/06 (8) conts

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

JL 07-01-07 (X5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-P 07/11/09 (8X)

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal B33184 (X3) JS

B35606 X5 -&gt; mul

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D2419 Handle B33186 JS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 35213

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D24620040

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0040 Seal

B29456

AS

13.0

D24620053

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0053 Seal

B29456

AS

14.0

D24620245

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0245 Seal

B29456

AS

15.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

B24215

AS

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

M6085

AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 21/11/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

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Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part Number	Description	Batch
1	MS20470AD4-6	Rivet	M105408

AD

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

mul

mul 07/11/15 x8

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-16 (8)

AS

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST217

AS 07/11/19 (8)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/19 (8)

Job Completion



07-11-19

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

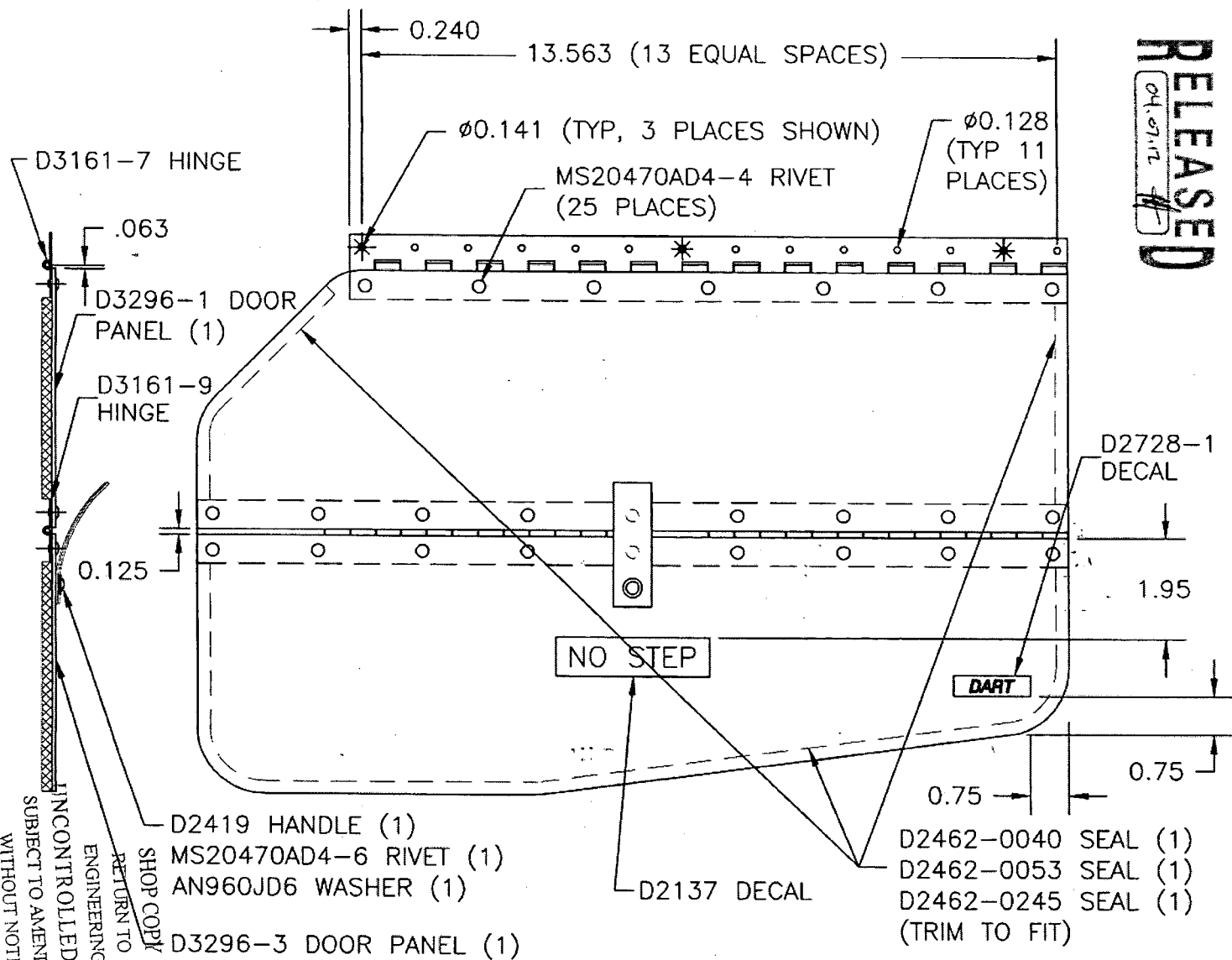
**NOTE:** Date & initial all entries





DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD
CHECKED	[Signature]	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA
DATE	04.06.28	DRAWING NO.	D3296	REV. A
		TITLE	DOOR ASSEMBLY	1 OF 2
				SCALE
A	04.06.28	NEW ISSUE		1:3

RELEASED  
04.07.12

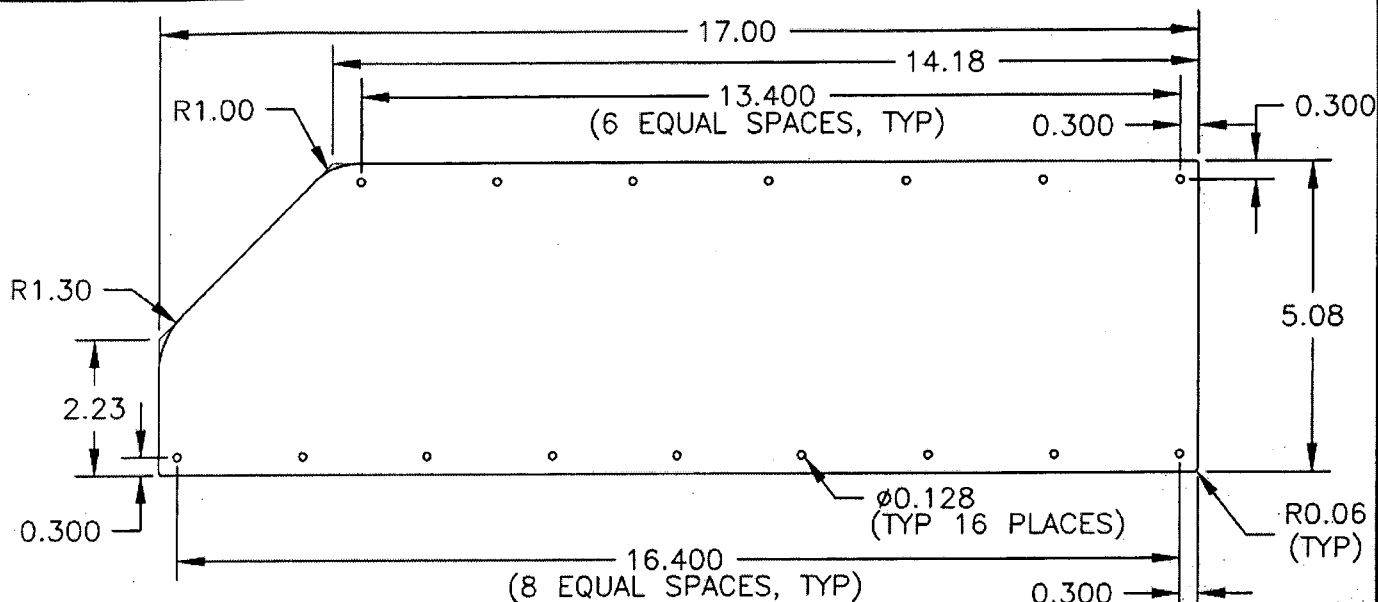


**D3296-041 DOOR ASSEMBLY**

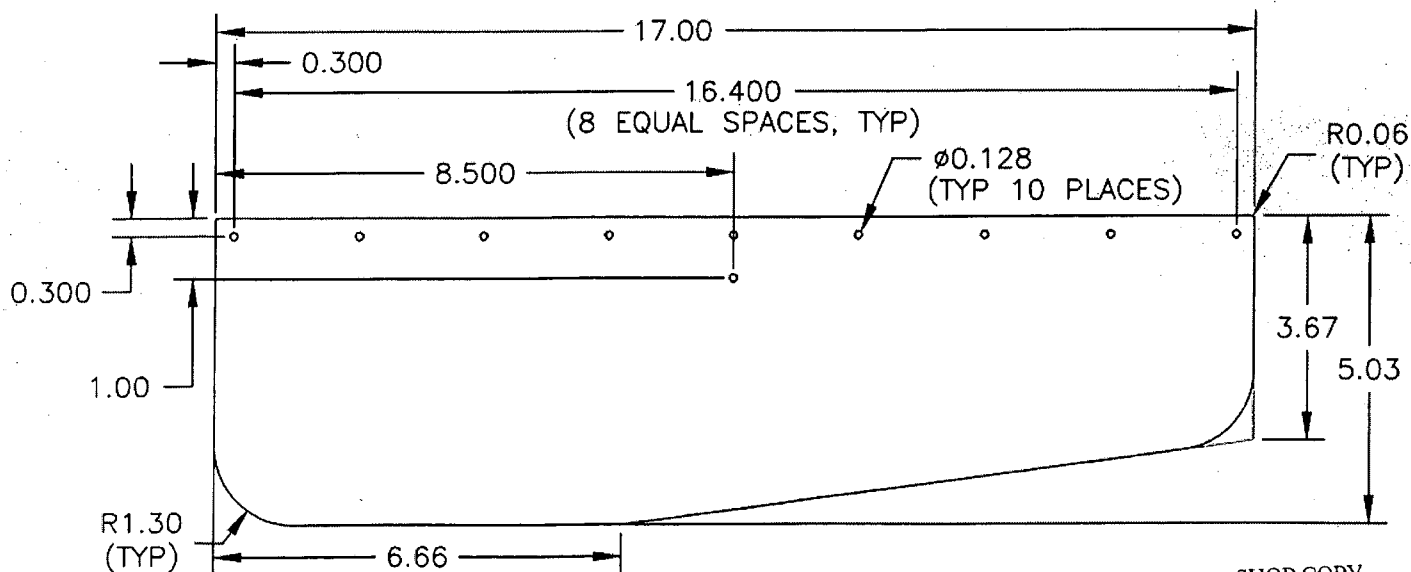
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



**D3296-1 DOOR PANEL**



**D3296-3 DOOR PANEL**

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WORK ORDER  
NO. 36213

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